



FOUNDRY Artcast

Investment powder for sculpture and art

ARTCAST™ is one of the original products designed by SRS. It is a plaster based Investment powder for brass / bronze castings using the lost wax process. ARTCAST™ is designed for the small to medium sized brass / bronze / small industrial casting.

ARTCAST™ offers the following benefits to the art foundries:

- ARTCAST™ is specially formulated for art casting in brass, bronze or silver.
- ARTCAST™ has extra strength to withstand larger mould sizes.
- ARTCAST™ is easy to mix and vacuum in larger quantities.
- ARTCAST™ already contains wetting and defoaming agents - no need to add.
- ARTCAST™ gives a smooth surface finish with perfect reproduction of wax patterns.
- ARTCAST™ is easy to break out after casting.
- ARTCAST™ is also available with water soluble fibres for added strength.
- ARTCAST™ can be packed in either 25kg bags or bulk bags up to 1500kg.



MIXING INSTRUCTIONS

Add the powder to the water in the recommended proportions in a mechanical mixer and mix for 4 minutes. Ideally the resultant slurry should be vacuumed for 1.1/2 minutes before being poured around the pattern, followed by a further vacuum of 1.1/2 minutes after the pattern has been covered. After vacuuming fill the pattern to the top. If there is insufficient time for both vacuum cycles omit the first cycle. Gentle vibration will also assist in the removal of air bubbles.

DRYING CYCLE

The moulds are allowed to stand for a minimum of 2 hours after mixing. The moulds may be dry dewaxed by heating them up to 200C and maintaining this temperature for 3 to 4 hours (size dependant). Increase the oven temperature at a rate of 70-90C per hour up to 725C. Burnout will be complete after 4 - 6 hours from reaching the final temperature. After burnout the moulds are allowed to cool to casting temperature at the natural cooling rate of the furnace.

Technical Information - ARTCAST™	
Powder/water ratio	38%
Work time @ 22°C	8 - 9 minutes
Initial set time	10 - 12 minutes
Thermal expansion @ 750°C	0.75%
Setting expansion € 2 hours	0.45%

